

503

1-00

Work Order ID 85219

85219

Page 1

June-04-12 3:50:01 PM

Item ID: D3954-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: GWT Pin

Start Date: 04/06/2012 Start Qty: 8.00

8

Cust Item ID:

Required Date: 18/06/2012 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals:

Process Plan: MLJDate: 12/06/04

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3954

C

100

0.00

100

Doosan

Memo

0.00

Doosan Lathe

1-Turn as per folio FA824 & dwg D3954

FOLIO REV: SLDWG REV: C

2-Deburr as required

SL 12/7/15

8 0

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

SL 12/7/15

8 0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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NOTE: Date & initial all entries

Picklist Print

June-04-12 3:50:05 PM

Page 1

Work Order ID: 85219

85219

Parent Item: D3954-1

D3954-1

Parent Item Name: GWT Pin

Start Date: 04/06/2012

Required Date: 18/06/2012

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP REV:A 11.08.16 AS PER REV.C DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M303R1.000

Purchased

No

100

f

28.6822

0.24

1.92

M303R1 000

**

SA 12/7/15

303 Round Bar 1.00

Location

Loc Qty

Loc Code

MAT028

28.68215789

120866

12

121070

3.31515789

121282

11.85

121728

1.517

2 Reet

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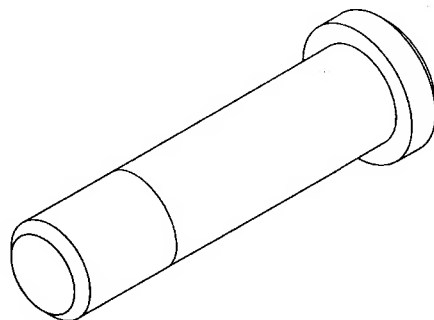
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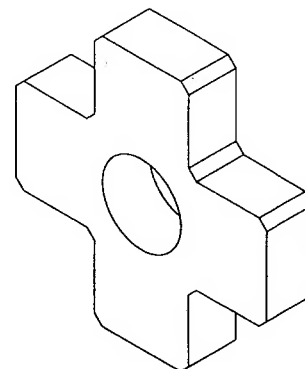
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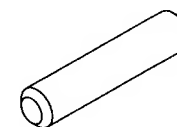
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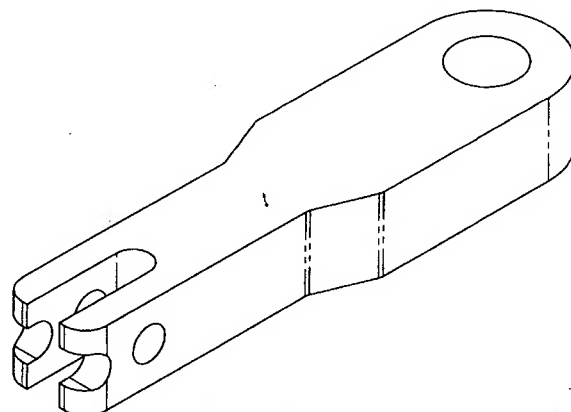
D3954-1 GWT PIN



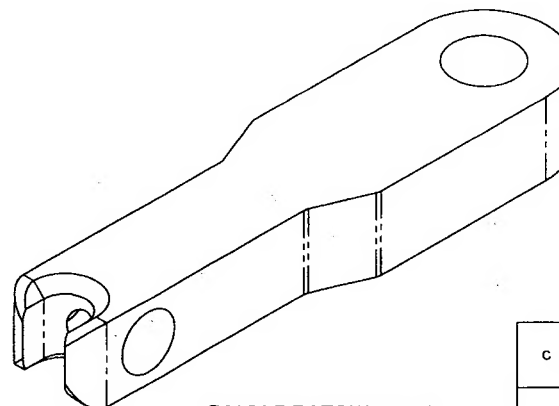
D3954-3 GWT KNOB



D3954-9 GWT CHAIN PIN



D3954-5 CHAIN LUG



D3954-7 RATCHET LUG

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 85219 MLT
12106104

RELEASED
2011-07-29

C	MATERIAL UPDATE FOR D3954-1/3: NOW STAINLESS STEEL ONLY (A8-2). FINISH CHANGED TO "NONE" FOR D3954-1/3 (A8-2). TOLERANCE ON Ø0.750 WAS Ø0.75 MAX (D3-3 & D7-3). D3954-9 NOW A PURCHASED PART (A2/A6-3). REASON: PART 11-113.	MB	11.07.27
B	MATERIAL UPDATE FOR ALL COMPONENTS WAS STAINLESS STEEL IS CARBON STEEL FOR ALL COMPONENTS. FINISH FOR ALL COMPONENTS WAS RED POWDER COAT IS YELLOW SPRAY PAINT.	AJS	09.10.15
A	NEW ISSUE	AJS	09.05.26
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS/DSTOW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO.	REV.
CHECKED		D3954	SHEET 1 OF 3
MFG. APPR.		TITLE	SCALE
APPROVED		MISC MACHINED PARTS GWT KIT	NT
DE APPR.	N/A	DATE 11.07.27	
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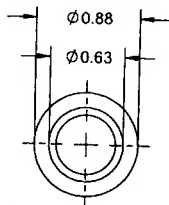
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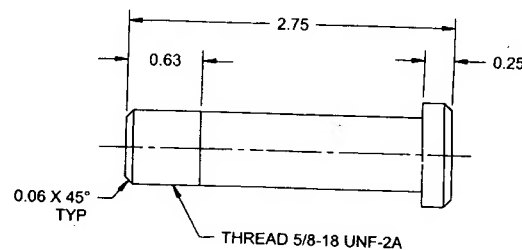
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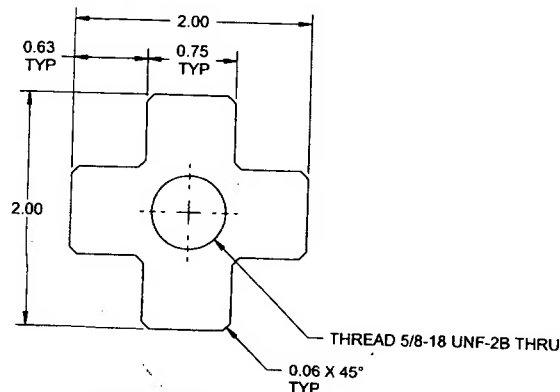
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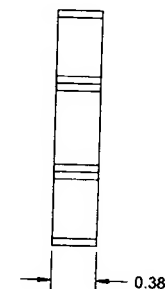
D3954-1 GWT PIN



85219



D3954-3 GWT KNOB



NOTES:

1) MATERIAL -1: AISI 303/304/316 STAINLESS STEEL ROUND BAR
PER ASTM A582 (303) OR ASTM A276 (304/316)
REF DART SPEC M303R OR M304R

-3: AISI 303/304/316 STAINLESS STEEL SHEET
PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316)
OR ASTM A240 OR ASME SA240
REF DART SPEC M303S OR M304S

OR:
AISI 303/304/316 STAINLESS STEEL BAR OR AISI 304/316 PLATE
PER ASTM A582 (303) OR A276 (304/316) OR ASTM A240 (304/316)
REF DART SPEC M303B OR M304B

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3954-X" USING FINE POINT PERMANENT INK MARKER

7) WEIGHT -1: 0.26 lbs
-3: 0.23 lbs

RELEASED
2011-07-29

DESIGN	AJS/DSTOW	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>AJS</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D3954	SHEET 2 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	N/A	MISC MACHINED PARTS GWT KIT	NTS
DATE	11.07.27	COPYRIGHT © 2009 BY DART AEROSPACE LTD	
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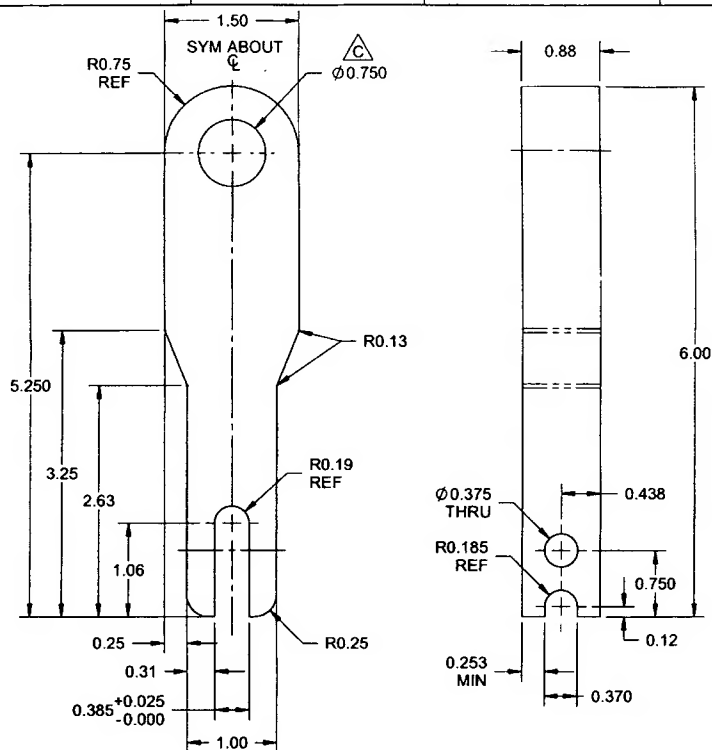
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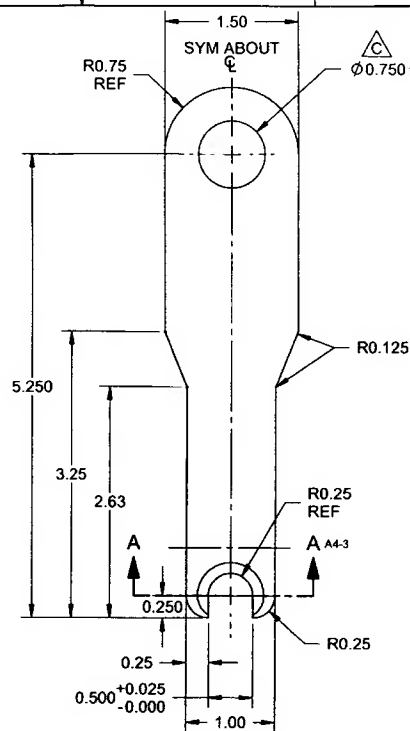
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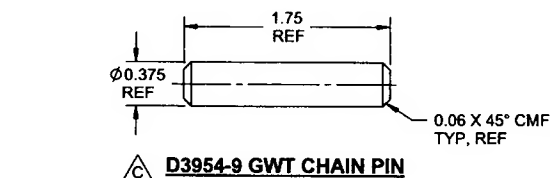
NOTE: Date & initial all entries



D3954-5 CHAIN LUG



D3954-7 RATCHET LUG



D3954-9 GWT CHAIN PIN

NOTES:

1) MATERIAL:

-5/-7: AISI 1010-1025 MILD STEEL BAR
PER DART SPEC M1010-B

-9: PURCHASE PART FROM MCMASTER-CARR:
P/N 98381A630 (MILD STEEL)

ALTERNATE MATERIAL:

-5/-7: AISI 303/304/316 STAINLESS STEEL BAR OR AISI 304/316 PLATE
PER ASTM A582 (303) OR A276 (304/316) OR ASTM A240 (304/316)
REF DART SPEC M303B OR M304B

-9: PURCHASE PART FROM MCMASTER-CARR:
P/N 90145A630 (STAINLESS STEEL)

2) FINISH -7 ONLY: SPRAY PAINT YELLOW WITH BERTRAND CG1031B PER DART QSI 005 4.2

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

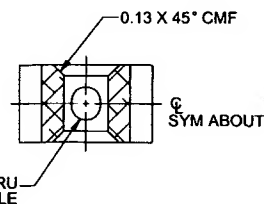
4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3954-X" USING FINE POINT PERMANENT INK MARKER

7) WEIGHT -5/-7: 1.56 lbs EACH

-9: 0.05 lbs REF



SECTION A-A

DESIGN	AJS/DSTOW	DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED	AJS	DRAWING NO. D3954
MFG. APPR.		REV. C
APPROVED		SHEET 3 OF 3
DE APPR.	N/A	SCALE
DATE	11.07.27	MISC MACHINED PARTS GWT KIT
		NTS

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